

Work Order ID 69371

Tuesday, May 10, 2011 1:22:28 PM



Page 1

Item ID: D3890-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel, Side

Start Date: 5/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/11/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date: 11-05-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3890

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3890-1

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B11-5-11

(2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-5-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

8 11/05/11

x2

130



Small Fab

Small Fab

Memo

Deburr if necessary

0.00

0.00

SB 11/05/11

2

140



Thermoform

Thermoforming Machine

Memo

Thermoform using mold DT9489 as per dwg

0.00

0.00

x2

Ph
11/05/11

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 5/11/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00



0.00 SB 11/05/11

QC

Memo

Quality Control

(72)

160

Pick Kit

0.00



0.00 SB 11/05/11

Packaging

Memo

Packaging

(2)

170

0.00



0.00 SB 11/05/11

Small Fab

Memo

Small Fab

1- Bond gasket to smooth side of panel as per dwg
A/R 3M 1300 adhesive Batch: M115230

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID: D3890-041

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Cust Item ID:

Required Date: 5/11/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/05/12

72

190

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PPN 69381
69382

Run 11/05/12 2

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/13

MF
11-05-12

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 10, 2011 1:22:41 PM

Page 1
T

Work Order ID: 69371



Parent Item: D3890-041

Parent Item Name: Panel, Side

Start Date: 5/10/2011

Required Date: 5/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.125-F60029-04		Purchased	No			100	sf	1,870.215	3.618	7.616842			
---------------------	--	-----------	----	--	--	-----	----	-----------	-------	----------	--	--	--



GE PLASTICS LEXAN SHEET



1811-5-11

Location

Loc Qty

Loc Code

MAT018

1870.215789

1870.21579

116236

D3890-3

Manufactured No

160

Each

0.0000

2

4



Gasket



B 69378

116236

(4)

23 11/05/11

W/O:		WORK ORDER CHANGES					
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

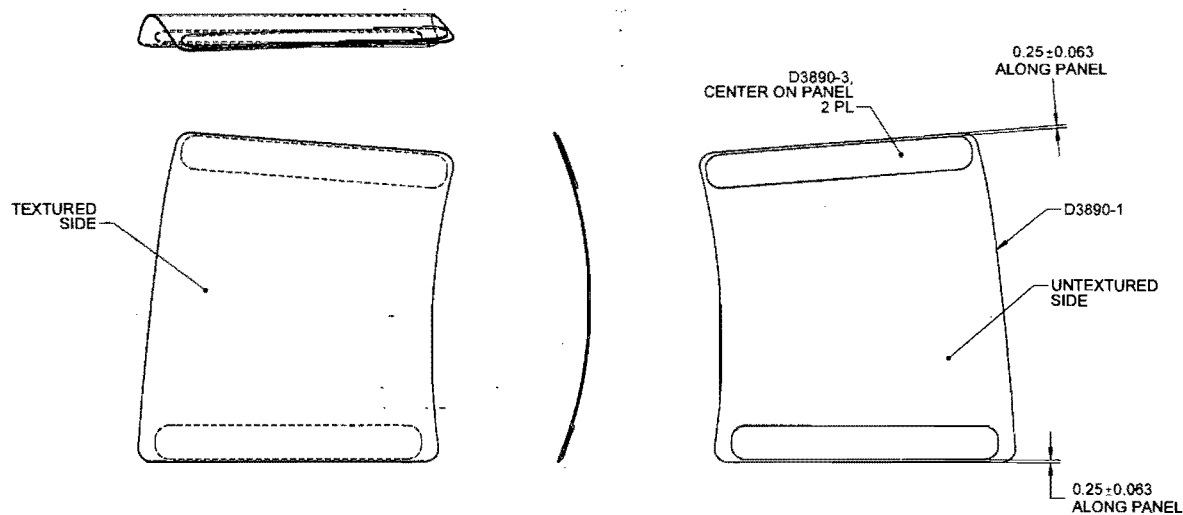
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PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3890-041	PANEL, SIDE
2	1	D3890-1	PANEL
3	2	D3890-3	GASKET
5	A/R	3M 1300	ADHESIVE

**D3890-041 PANEL, SIDE**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3890-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.48 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69371

2/11-05-10
RELEASED
2/16/10

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN	90		
DRAWN	90		
CHECKED	PH		
MFG. APPR.	21		
APPROVED	29		
DE APPR.	21		
DATE	09.05.01		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	SHEET 1 OF 4
DRAWING NO. D3890		TITLE	SCALE
PANEL, SIDE			NTS
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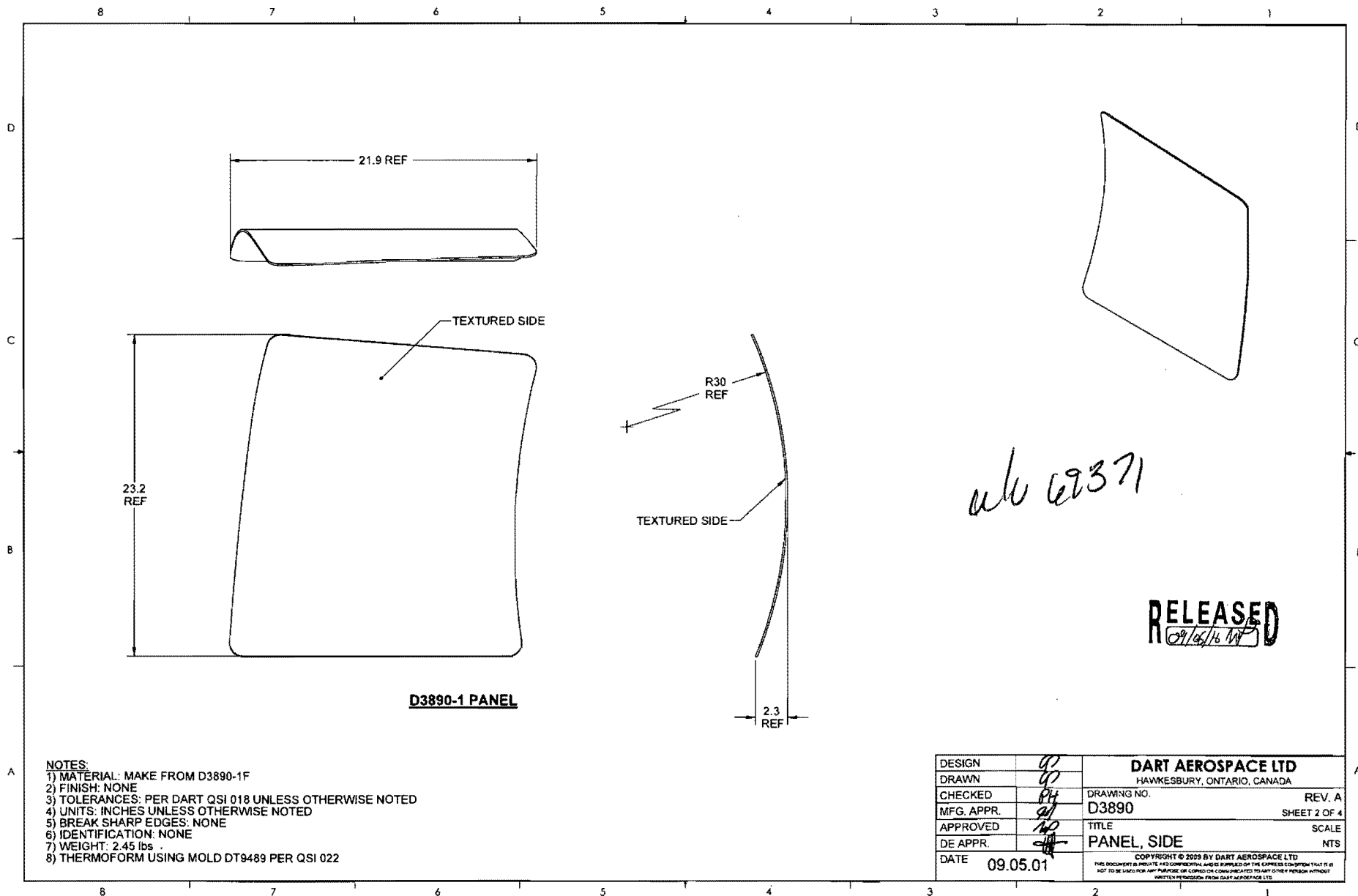
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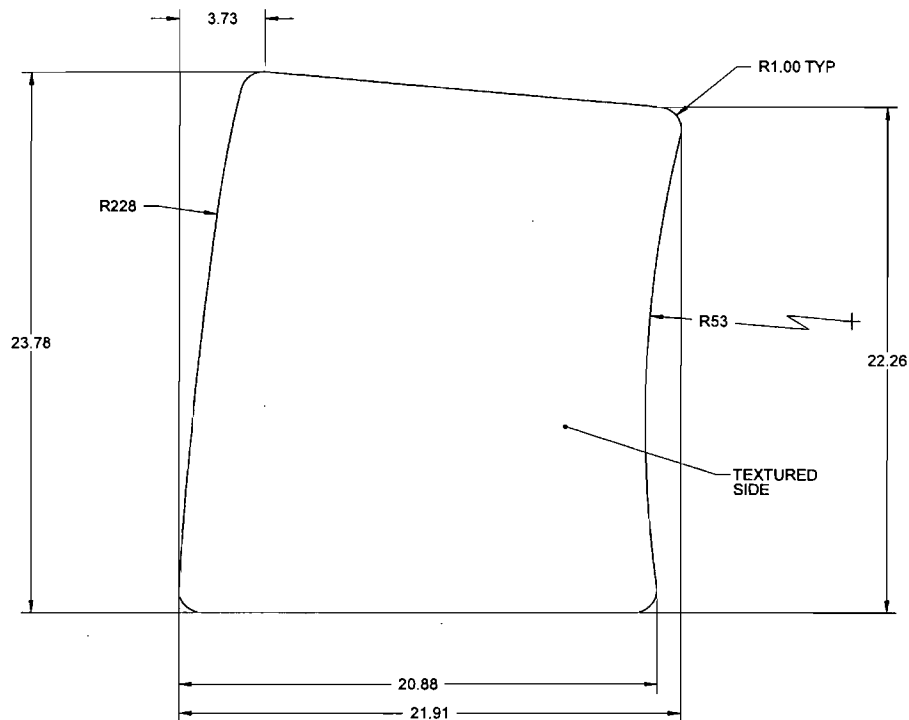
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NOTE: Date & initial all entries



D3890-1F PANEL

u/o 69371

RELEASED
9/06/16

NOTES:

- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.45 lbs

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	2/1	D3890	SHEET 3 OF 4
APPROVED	4/2	TITLE	SCALE
DE APPR.	4/2	PANEL, SIDE	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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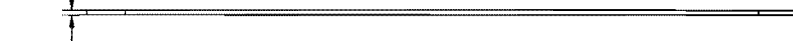
NOTE: Date & initial all entries

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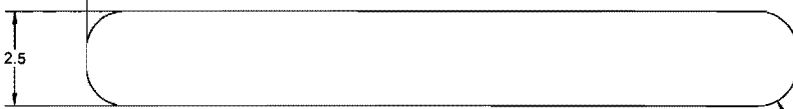
D

0.125
REF



C

C



R1.0
TYP

D3890-3 GASKET

u/o: 69371

RELEASED
09/06/14

B

B

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	21	D3890	SHEET 4 OF 4
APPROVED	12	TITLE	SCALE
DE APPR.	11	PANEL, SIDE	NTS
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8 7 6 5 4 3 2 1

A

A

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